

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66994

Thursday, March 03, 2011 10:16:08 AM



Page 2

Item ID: D3293-1

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 3/3/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1- Deburr								
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
150 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

n/a S

~~12 11-3-8~~

12 11-3-8

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Page 3

Item ID: D3293-1

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 3/3/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

M 112588

Memo

0.00

Powder Coating

START TIME: *11:45*

OVEN TEMPERATURE:

320 FINISH TIME: *12:15*

12 BR 11-3-9

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

12 d M 11/03/09

180

Identify as per dwg & Stock Location: *211*

0.00



Packaging

Memo

0.00

Packaging

12 4/3/10 (12)

Dart Aerospace Ltd

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Thursday, March 03, 2011 10:16:08 AM



Page 4

Item ID: D3293-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 3/3/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/10

PL 11-03-10
(12)

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Picklist Print

Thursday, March 03, 2011 10:16:13 AM

Page 1

Work Order ID: 66994

Parent Item: D3293-1

Parent Item Name: Doubler




Start Date: 3/3/2011

Required Date: 3/11/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: ☐A☐04.08.24☐New issue☐KJ/JLM☐
IPP Rev:B Now on Waterjet 06-11-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.080  2024-T3 .080 sheet		Purchased		No		100	sf	84.4400	1.8264	19.22526		3/3/11 20.1 1311-3-3	

Location

Loc Qty

Loc Code

MAT		35	
116604		35	
MAT22		49.44	
104921		2	
105411		7	
109424		2.74	
110347		3	
110908		2	
112331		3	
113796		9.7	
114025		20	

$$116604 \times 8 = 14.7$$

$$113796 \times 4 = 7.4$$

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DART AEROSPACE LTD		Work Order:	66994
Description: Doubler		Part Number:	D3293-1
Inspection Dwg: D3293 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.350	+/-0.010	0.353	✓		V 1B02	
0.650	+/-0.010	0.657	✓		V	
1.874	+/-0.010	1.881	✓		V	
Ø0.141	+0.005/-0.001	0.143	✓		V	
Ø0.128	+0.005/-0.001	0.131	✓		V	
17.750	+/-0.010	17.750	✓		T 1B01	
20.15	+/-0.030	20.15	✓		T	
R0.350	+/-0.010	0.350	✓		R.G	
R0.312	+/-0.010	0.312	✓		R.G	
0.080	+/-0.010	0.080	✓		V	

Measured by: IB	Audited by: D	Prototype Approval:	N/A
Date: 11-3-3	Date: 11/03/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	KJ/JLM	
B	08.10.09	0.080 dimension added	KJ/DD	

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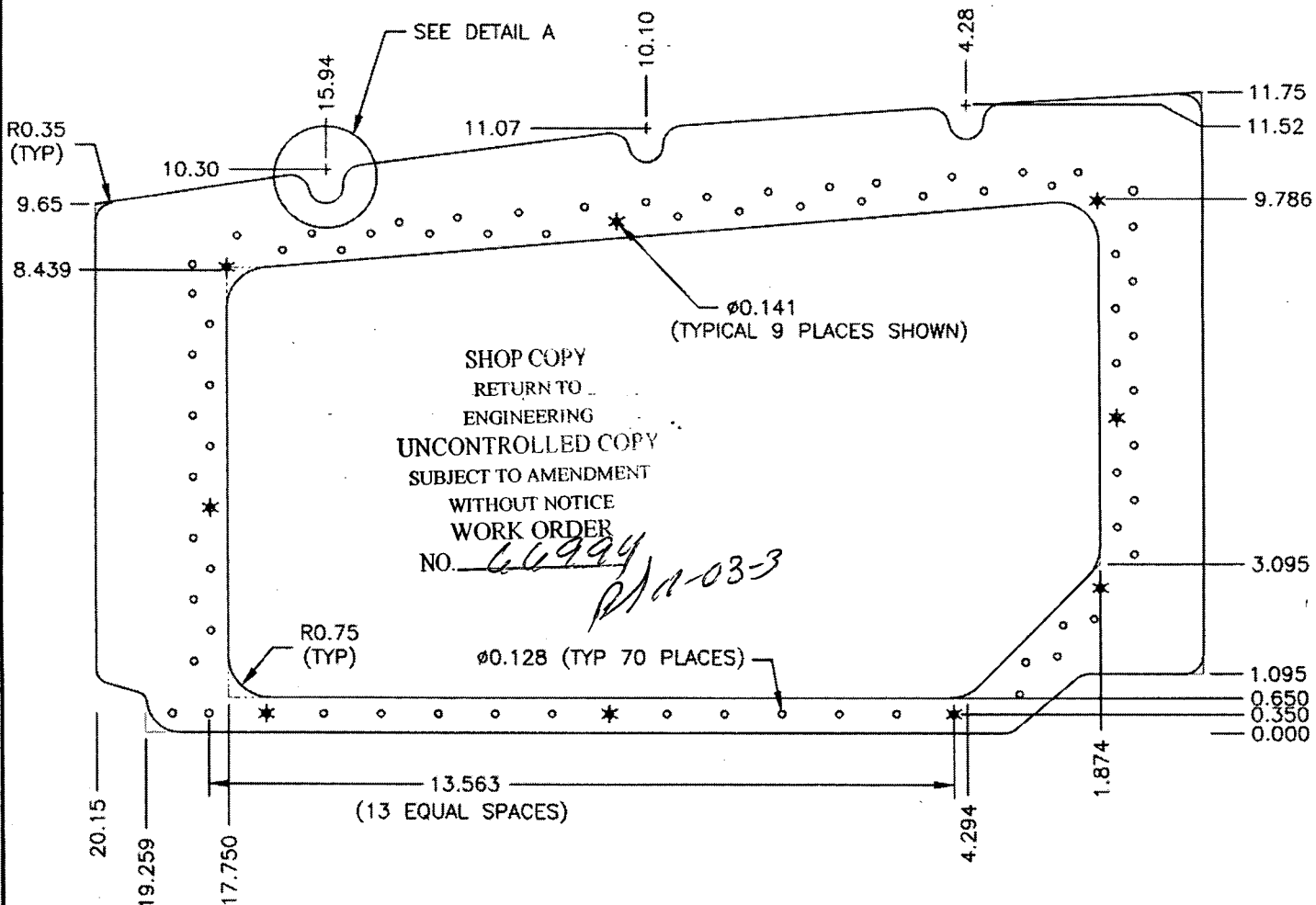
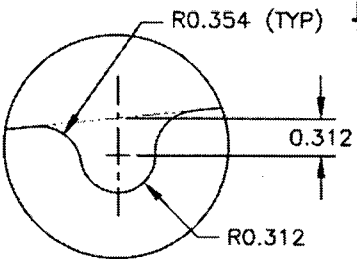
NOTE: Date & initial all entries

QA COPY ISSUED

DESIGN		DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO.	REV. A
DATE	04.06.28		D3293		SHEET 1 OF 1
			TITLE	DOUBLER	SCALE
					1:3
A	04.06.28		NEW ISSUE		

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

04.07.12 - #



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